

Date: Friday, 2/3/2006 8:30:46 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 25721  
 Estimate Number : 12027  
 P.O. Number : N/A  
 This Issue : 2/3/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : 2/3/2006 Type : LARGE FAB ASSY  
 Previous Run : 22512  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J  
 LM

Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)  
 Part Number : D412630024  
 Drawing Number : RETURN TO STOCK  
 Project Number : N/A  
 Drawing Revision : J  
 Material : N/A  
 Due Date : 2/10/2006 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-024 CHG002

D4 02/03/24  
 ①

2.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT PART

original B# B22510

06-02-03

3.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

TOUCH UP / REPAINT PARTS IF REQUIRED.

FC 06 02 07

4.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-02-13

5.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Pick:

Qty Part Number Description  
 2 AN310C8 Nut

Batch  
 M17997

Date: Friday, 2/3/2006 8:30:46 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 25721

Part Number: D412630024

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D33951	Bushing
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bushing

B23634

7.0	AN3C21A	BOLT
-----	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOLT

M18515

8.0	AN310C8	Nut
-----	---------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Nut

Item replaced

N/A

~~11813~~

9.0	AN8C16	Bolt
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M18143

10.0	MS210433	Nut
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M19099

11.0	MS24665302	Cotter Pin
------	------------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

Date: Friday, 2/3/2006 8:30:46 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 25721

Part Number: D412630024

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M1694

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M17944

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M19349

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M18779

SAD 06-02-13

16.0 ~~QPLS~~ INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Inspect work on Assy

06-02-13

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location:

PPP Rev:

A

1/4 8/2/00

(1)

Date: Friday, 2/3/2006 8:30:47 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 25721

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

DC

DOCUMENT CONTROL



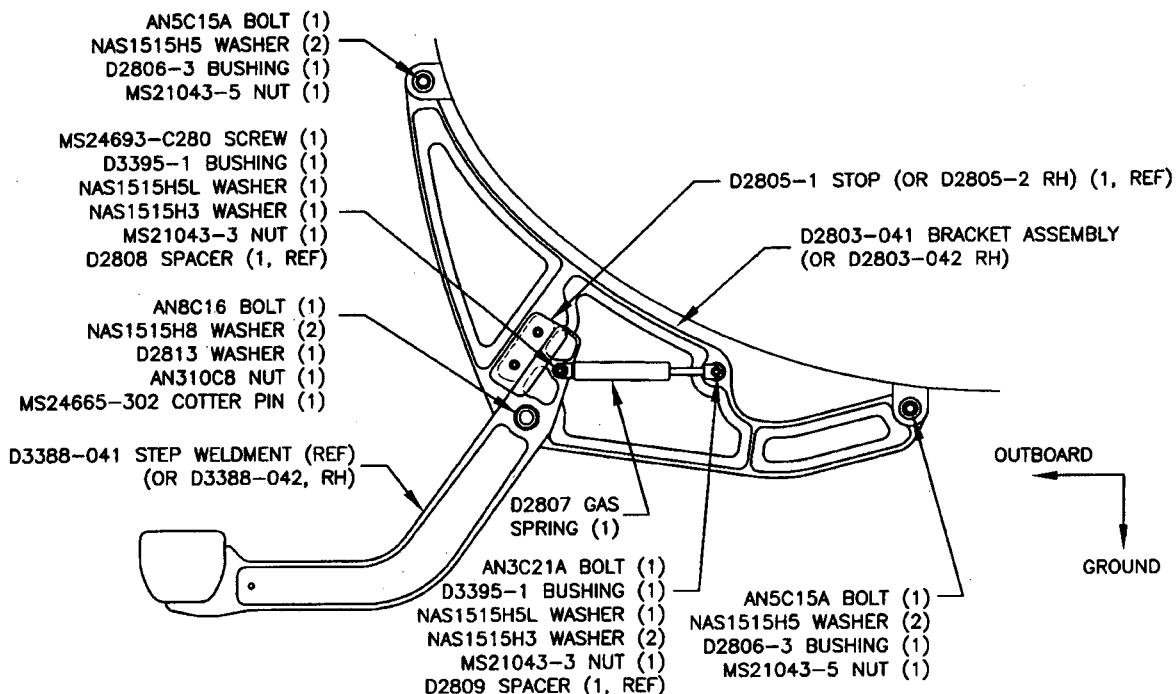
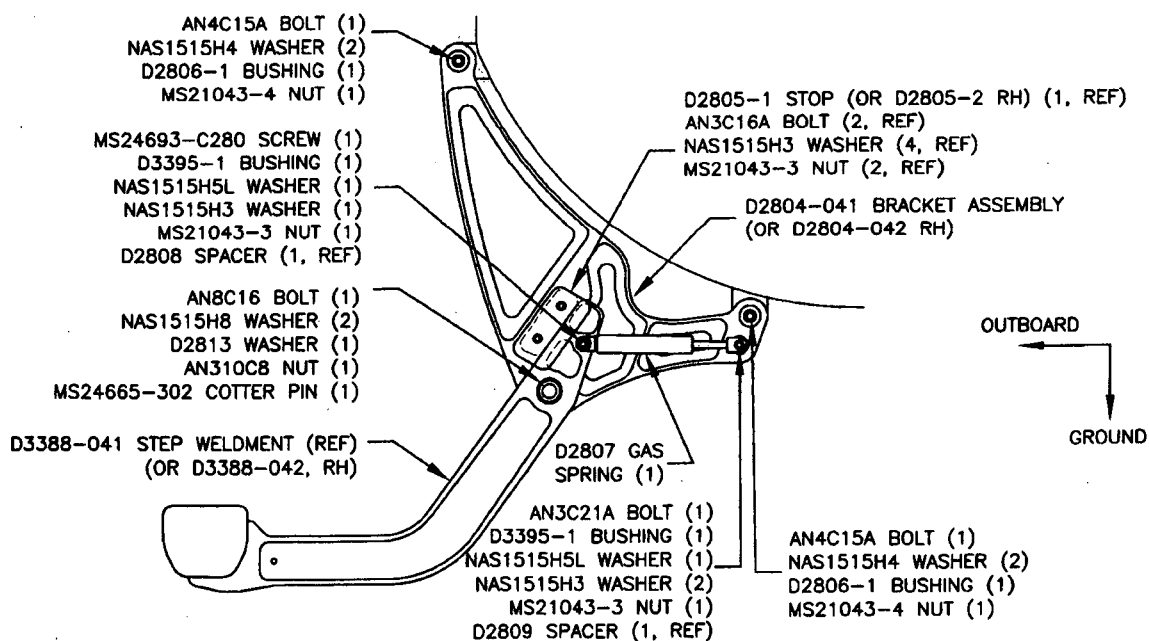
Comment: DOCUMENT CONTROL  
Inspection Level 21

06/03/21

Job Completion



U 06-03-21

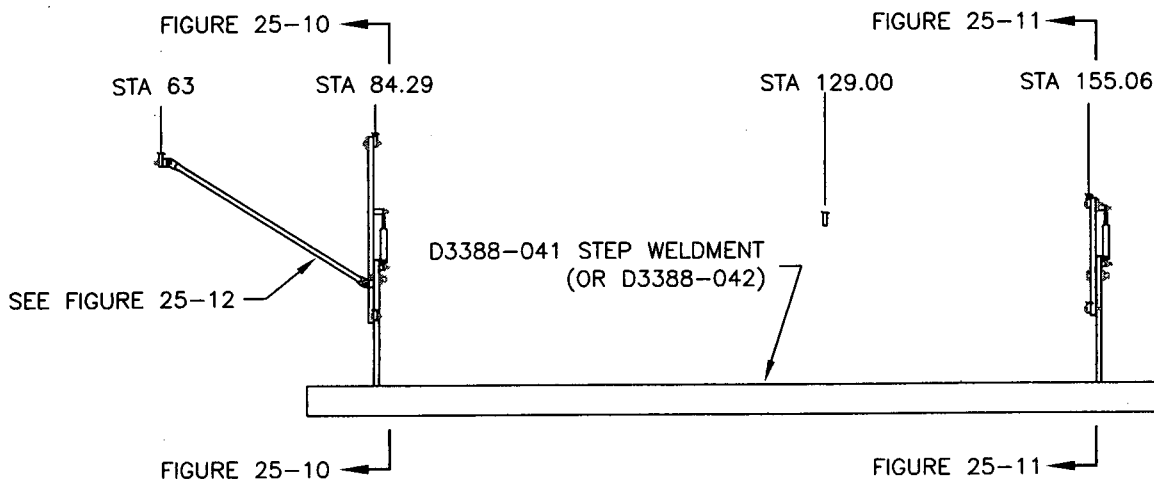
**D412-630-023/-024 Heli-Access-Step™ Installation****FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation**  
(View rotated 90° CW)**FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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Revision: J  
Date: 05.12.08

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)  
 D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



REFERENCE ONLY

D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)  
 D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

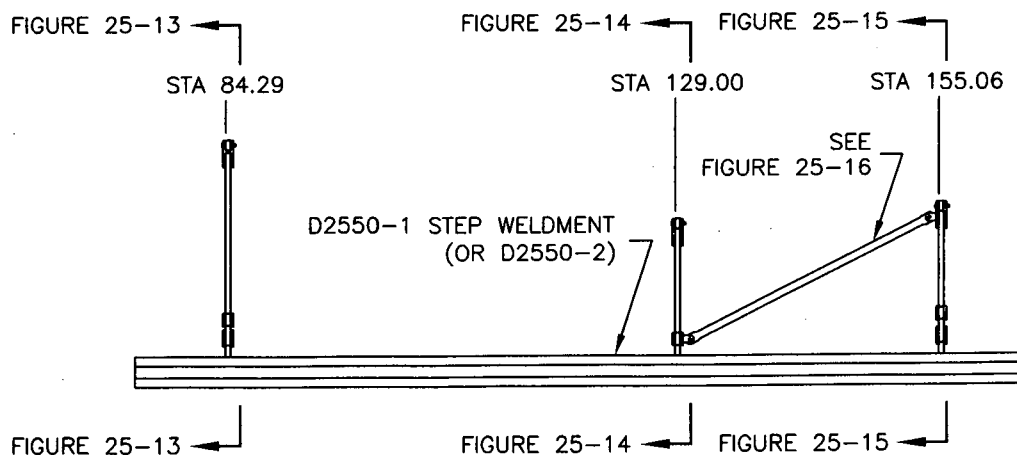


FIGURE 25-2: D412-630 Heli-Access-Step™ Installations

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 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00

5115

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 22510
<b>Description:</b> Folding Step Installation RH	<b>Part Number:</b> D412-630-024
<b>Dwg:</b> D412-630 Rev. H page 6, 11-12	<b>Qty:</b> 5
	Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																																				
1	DC	Issue Traveler <b>Dwg not required</b>	PA	05.02.23	5																																																																				
2	DC	Photocopy bluefile and create labels as per PPP D412-630-024 <b>CHG001</b>	DK	05.06.15	5																																																																				
3	GA <i>UP 05.06.15</i>	Assemble as per Dwg D412-630 <b>Pick:</b> Qty (4) NAS 1515H3L WASHER <i>M17569</i> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2012-107</td><td>Clevis</td><td>B23</td></tr><tr><td>1</td><td>D2803-042</td><td>Bracket Assembly RH</td><td>B22514B</td></tr><tr><td>1</td><td>D2804-042</td><td>Bracket Assembly RH</td><td>B22516B</td></tr><tr><td>2</td><td>D2807</td><td>Gas Spring</td><td>B23565</td></tr><tr><td>2</td><td>D2813</td><td>Washer</td><td>B22517</td></tr><tr><td>1</td><td>D3388-042</td><td>Step Weldment RH</td><td>B22519A</td></tr><tr><td>4</td><td>D3395-1</td><td>Bushing</td><td>B22520</td></tr><tr><td>2</td><td>AN3C20A</td><td>Bolt</td><td>M17569</td></tr><tr><td>2</td><td>AN310C8</td><td>Nut</td><td>M16941</td></tr><tr><td>2</td><td>AN8C16</td><td>Bolt</td><td>M17186</td></tr><tr><td>4</td><td>MS21043-3</td><td>Nut</td><td>M17239</td></tr><tr><td>2</td><td>MS24665-302</td><td>Cotter Pin (or AN380C3-4)</td><td>M16941</td></tr><tr><td>2</td><td>MS24693-C280</td><td>Screw (or MS24694-C565)</td><td>M16941</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M17189</td></tr><tr><td>3</td><td>NAS1515H4</td><td>Washer</td><td>M16984</td></tr><tr><td>4</td><td>NAS1515H8</td><td>Washer</td><td>M16984</td></tr></table>	Qty	Part Number	Description	Batch	1	D2012-107	Clevis	B23	1	D2803-042	Bracket Assembly RH	B22514B	1	D2804-042	Bracket Assembly RH	B22516B	2	D2807	Gas Spring	B23565	2	D2813	Washer	B22517	1	D3388-042	Step Weldment RH	B22519A	4	D3395-1	Bushing	B22520	2	AN3C20A	Bolt	M17569	2	AN310C8	Nut	M16941	2	AN8C16	Bolt	M17186	4	MS21043-3	Nut	M17239	2	MS24665-302	Cotter Pin (or AN380C3-4)	M16941	2	MS24693-C280	Screw (or MS24694-C565)	M16941	4	NAS1515H3	Washer	M17189	3	NAS1515H4	Washer	M16984	4	NAS1515H8	Washer	M16984	SP	05/06/15	5
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4	NAS1515H8	Washer	M16984																																																																						
4	QC5	Inspect work to Step 3	PA	05.06.14	5																																																																				
5	KP <i>UP 05.06.15</i>	<b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2806-1</td><td>Bushing</td><td>B22239/B</td></tr><tr><td>2</td><td>D2806-3</td><td>Bushing</td><td>B22510</td></tr><tr><td>1</td><td>D2810-5</td><td>Strut</td><td>B22560</td></tr><tr><td>2</td><td>D3396-1</td><td>Spacer</td><td>B22535</td></tr><tr><td>1</td><td>AN4C6A</td><td>Bolt</td><td>M1783L</td></tr><tr><td>1</td><td>AN4C10A</td><td>Bolt</td><td>M18515</td></tr><tr><td>2</td><td>AN4C15A</td><td>Bolt</td><td>M17997</td></tr><tr><td>1</td><td>AN44-C7A</td><td>Eyebolt</td><td>M17992</td></tr><tr><td>2</td><td>AN5C15A</td><td>Bolt</td><td>M18775</td></tr><tr><td>4</td><td>MS21043-4</td><td>Nut</td><td>M18535</td></tr><tr><td>3</td><td>MS21043-5</td><td>Nut</td><td>M18535</td></tr><tr><td>8</td><td>NAS1515H4</td><td>Washer</td><td>M18535</td></tr><tr><td>7</td><td>NAS1515H5</td><td>Washer</td><td>M18143</td></tr></table>	Qty	Part Number	Description	Batch	2	D2806-1	Bushing	B22239/B	2	D2806-3	Bushing	B22510	1	D2810-5	Strut	B22560	2	D3396-1	Spacer	B22535	1	AN4C6A	Bolt	M1783L	1	AN4C10A	Bolt	M18515	2	AN4C15A	Bolt	M17997	1	AN44-C7A	Eyebolt	M17992	2	AN5C15A	Bolt	M18775	4	MS21043-4	Nut	M18535	3	MS21043-5	Nut	M18535	8	NAS1515H4	Washer	M18535	7	NAS1515H5	Washer	M18143	PA	05/06/15	5												
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8	NAS1515H4	Washer	M18535																																																																						
7	NAS1515H5	Washer	M18143																																																																						
6	QC4	Inspect Kit 100% for Completeness on the W/O	PA	05.06.13	5																																																																				
7	PK	Identify and pack for shipping as per PPP D412-630-024	PA	05/06/15	5																																																																				
8	AC	Cost / part: <i>417.24</i>	PA	05/06/16	5																																																																				
9	DC	Close W/O <i>417.24</i> Inspect Level 21	PA	05.06.15	5																																																																				

Rev	Date	Change	Revised By	Approved
A	05.02.22	New issue	KJ/JLM	